

Date: Tuesday, 4/4/2006 1:35:31 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT TUBE ASSEMBLY
<b>Job Number</b> : 26531	
<b>Estimate Number</b> : 10699	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3391025
<b>This Issue</b> : 4/4/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3391 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 26466	<b>Material</b> : N/A
<b>Written By</b> : <i>SKL</i> <i>COMMENT Below</i>	<b>Due Date</b> : 4/24/2006
<b>Checked &amp; Approved By</b> : <i>KA 06.04.04</i>	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> : Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



**Comment:** Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D6014-090	Extrusion	<u>D24315 (D6014-104)</u>
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Identify as D3391-3

M8 06/04/06

1

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: D

M8 06/04/06

1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/04/02

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

BC 06.04.08

1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/06	1	3.500 inside bore is 3.530						

**NOTE:** Date & initial all entries

Date:  
User:

Tuesday, 4/4/2006 1:35:31 PM  
Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26531

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BE 06-04-08

1

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.G

06/04/08 1

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

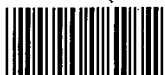
Form as per Dwg D3391 Using Bend Prog 3391025

DP06-4-9

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-10

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

DP06-4-10

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

DP06-4-10

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

BE 06-04-11

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

BE 06-04-11

5-Deburr

BE 06-04-11

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-11

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per OSI 0054-1

a.m 06-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26531

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-24 (1)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0 AESS10KB366 INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M17905

15.0 NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M1007B2

16.0 AESS10KB266 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

M17905

or NAS1330C3KB266

17.0 AESS10KB316 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

M17905

or NAS1330C3KB316

a.m 06-04-25 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:35:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26531

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	<u>D 20208</u> ✓

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	<u>M 19522</u> ✓

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	<u>M 18822</u> ✓

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	<u>M 19185</u> ✓

Q. m 06-04-25 (1)

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M 100980

Sikaflex expiry date: 06-11-06

Q. m 06-04-25 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 4/4/2006 1:35:32 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26531

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1001 04/25 (1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

DL 04/04/25 (1)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/27 (1)

Job Completion



u 06-04-27

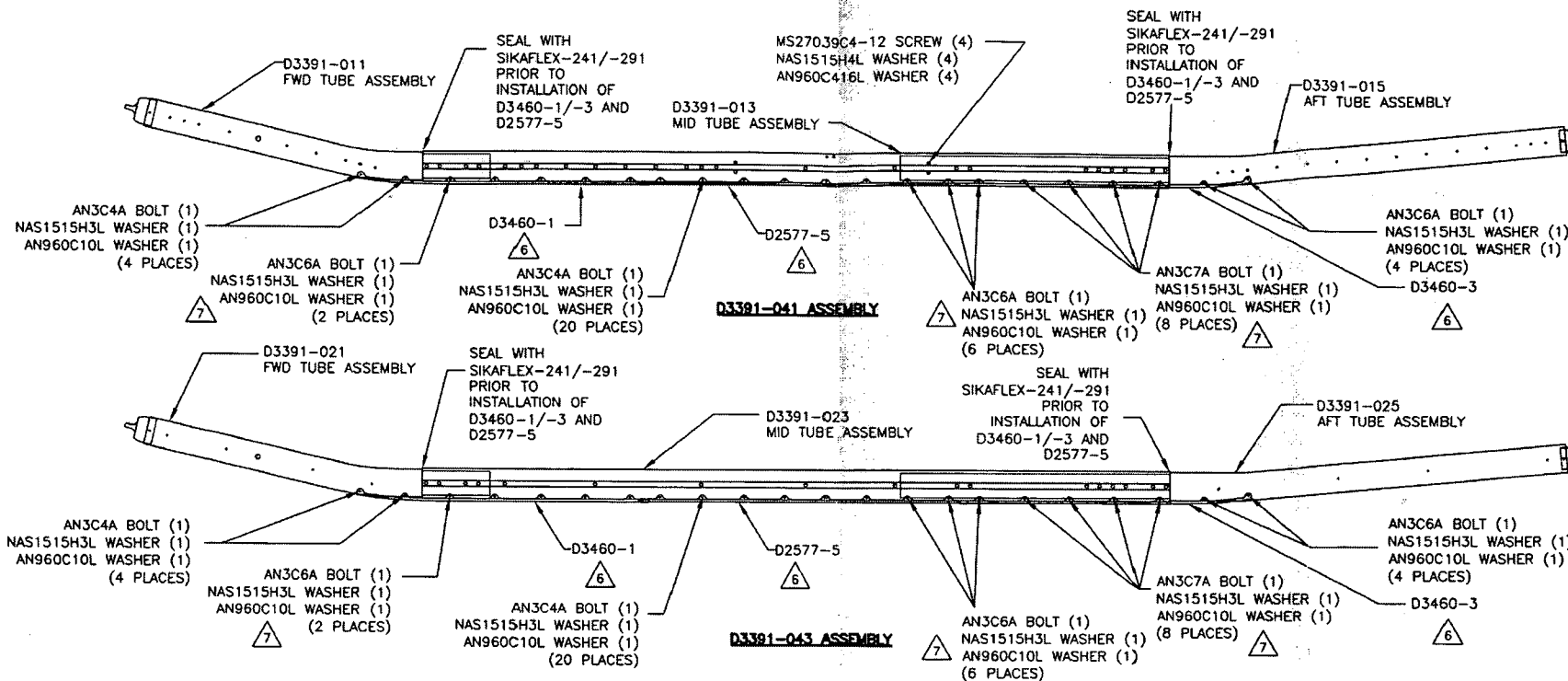
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# **D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

## **GENERAL NOTES**

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018, UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

NO. 26531  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

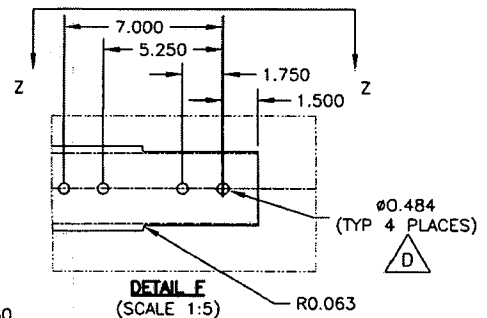
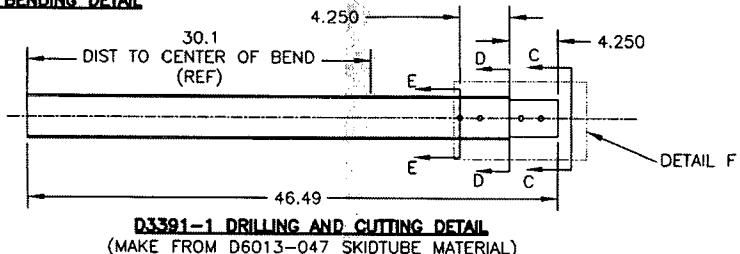
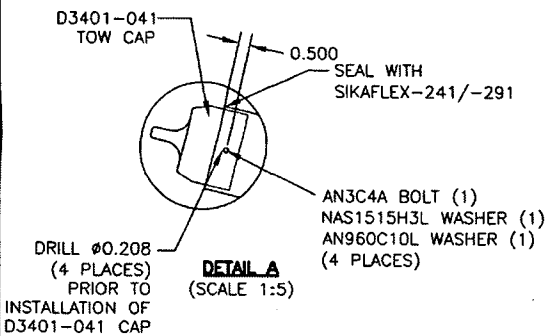
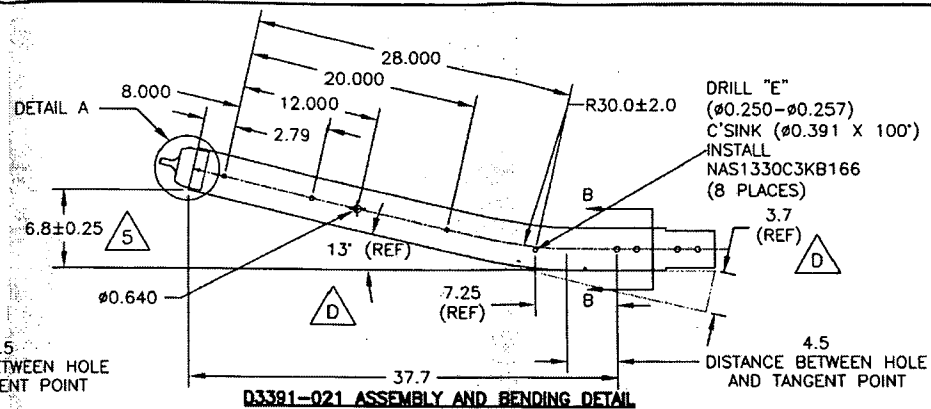
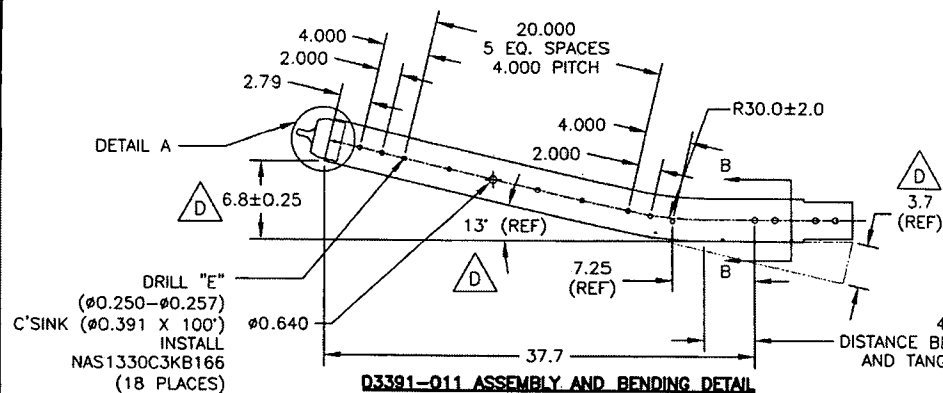
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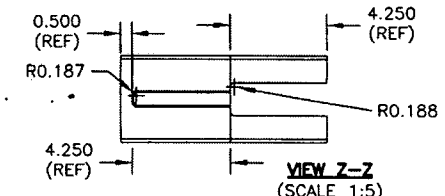
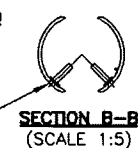
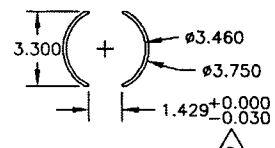
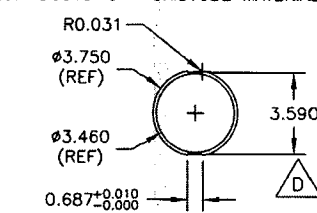
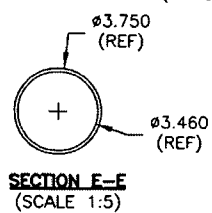
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C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE USA, INC. PORT WASHINGTON, WA
CHECKED	APPROVED	DRAWING NO. D3391
DATE	06.01.23	TITLE 412 FLOAT SKIDTUBE
		REV. 0 SHEET 1 OF 5 SCALE NTS

RELEASED

06.01.27



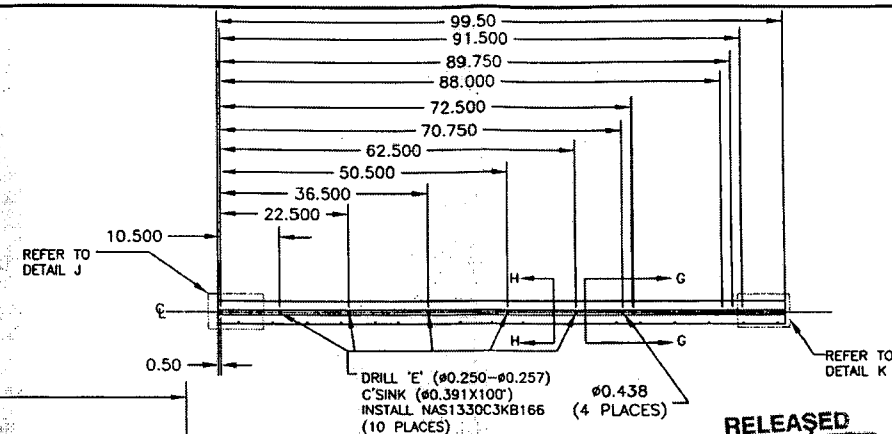
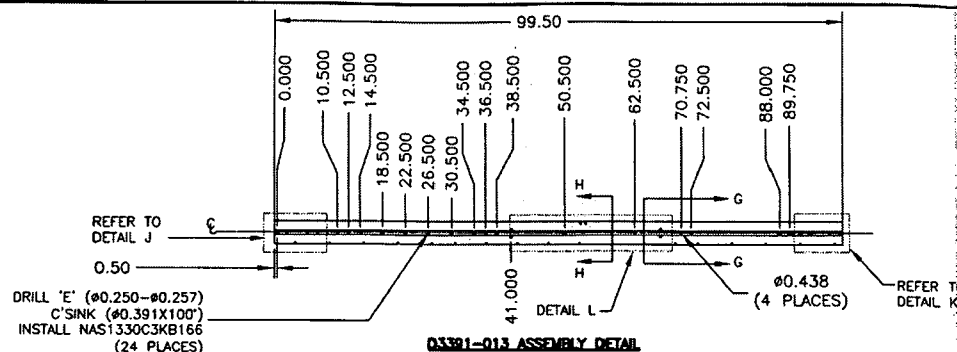
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT



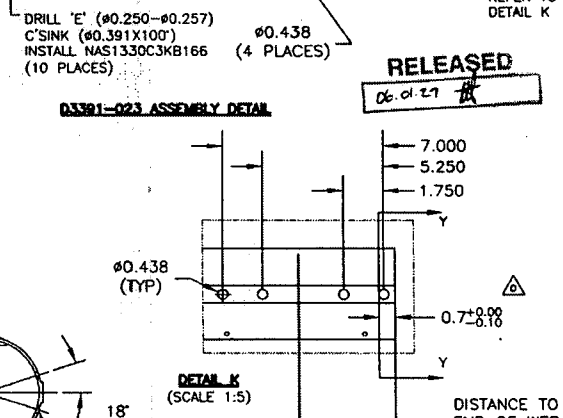
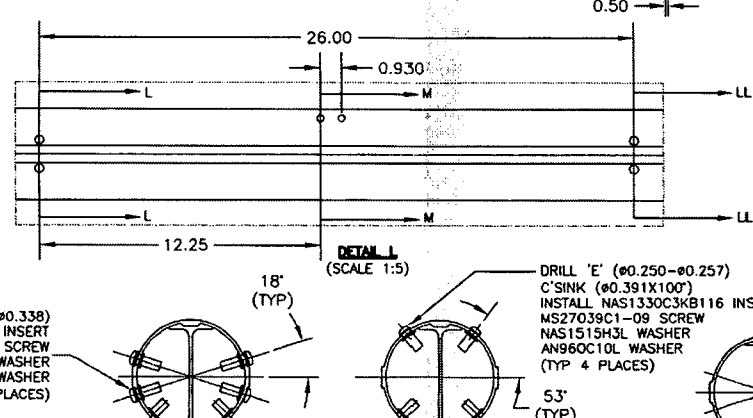
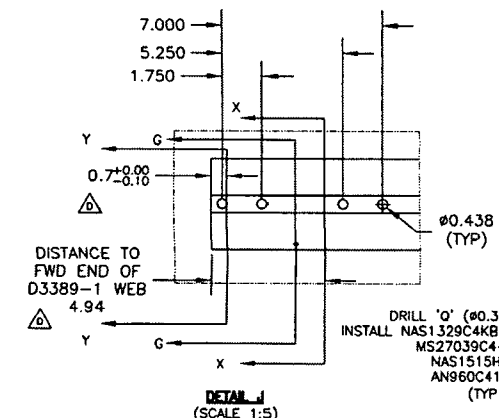
RELEASED  
06-01-27

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED #	APPROVED #	DRAWING NO. D3391		REV. D SHEET 2 OF 5	
DATE 06.01.23		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10	

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
26531



RELEASED  
06-01-27



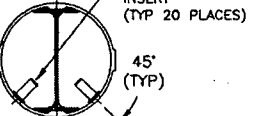
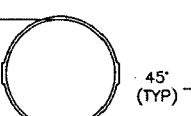
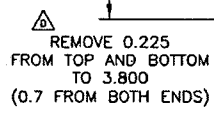
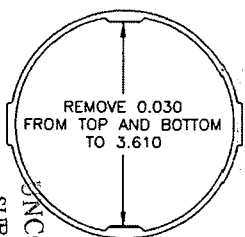
**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

SECTION L-L  
(SCALE 1:4)

SECTION M-M  
(SCALE 1:4)

SECTION N-N  
(SCALE 1:4)

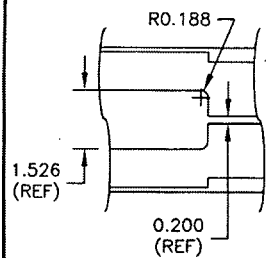


D3391-013/-023 MID TUBE ASSEMBLY  
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 013  
WORK ORDER 26531  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
COPY  
SCALE 1:2

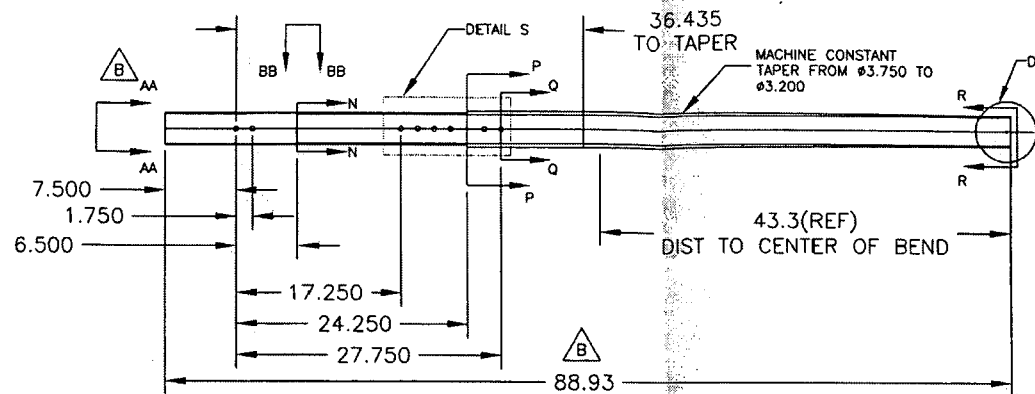
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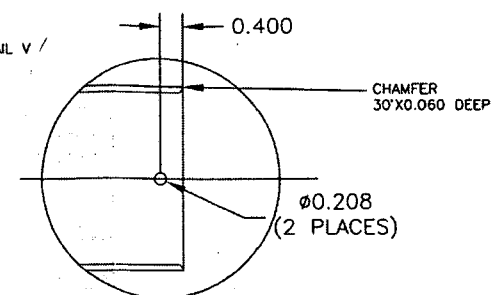
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. D
CHECKED #	APPROVED #		SHEET 3 OF 5
DATE 06.01.23	DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20



VIEW BB-BB  
(SCALE 1:3)



D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

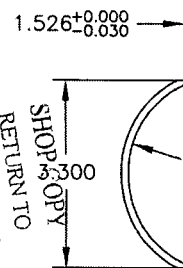


DETAIL V  
(SCALE 1:2)

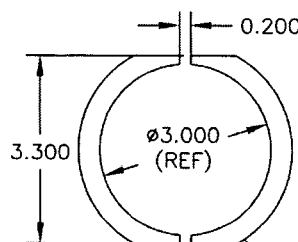
RELEASED

06-01-27

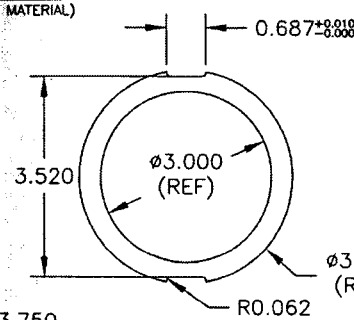
NO. 26531  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
UNCONTROLLED COPY  
RETURN TO  
SHOP COPY  
1.526<sup>+0.000</sup><sub>-0.030</sub>



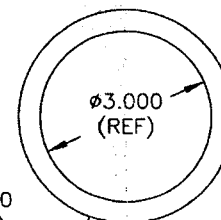
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(SCALE 1:2)



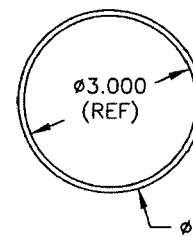
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(SCALE 1:2)



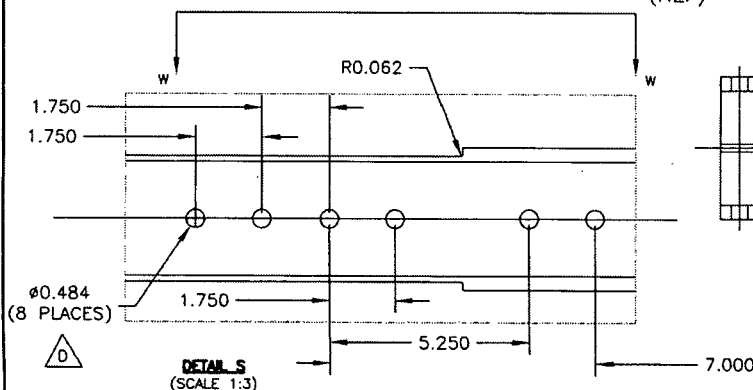
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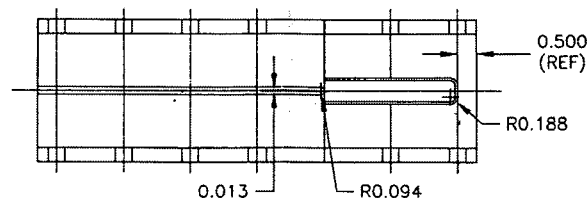
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

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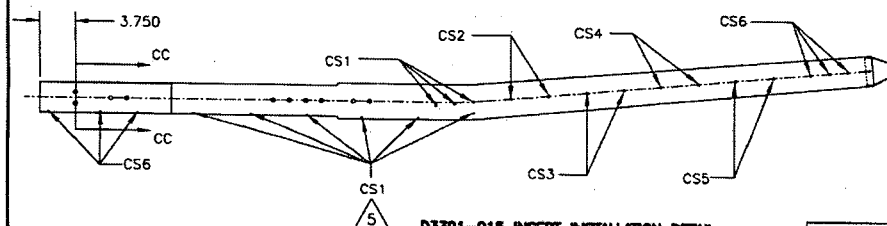
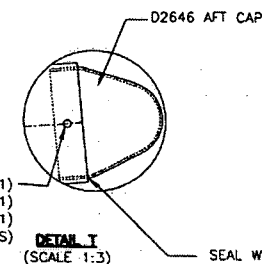
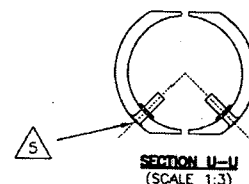
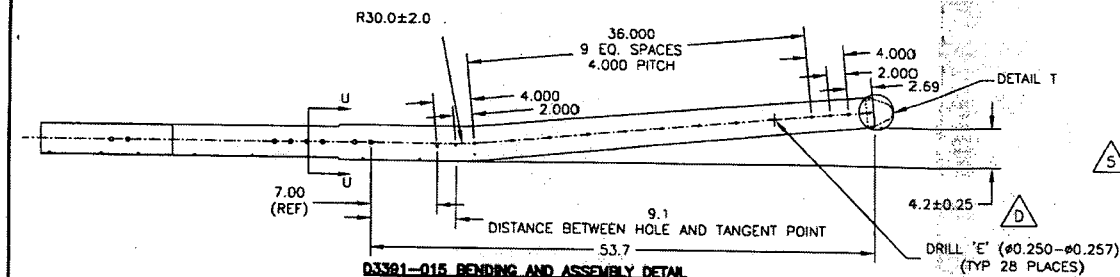
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**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA  
DRAWING NO.  
D3391  
TITLE  
412 FLOAT SKIDTUBE  
REV. D  
SHEET 4 OF 5  
SCALE  
1:12

RELEASED  
06.01.27

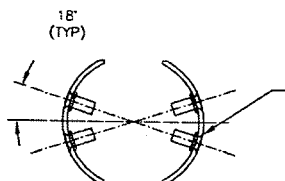
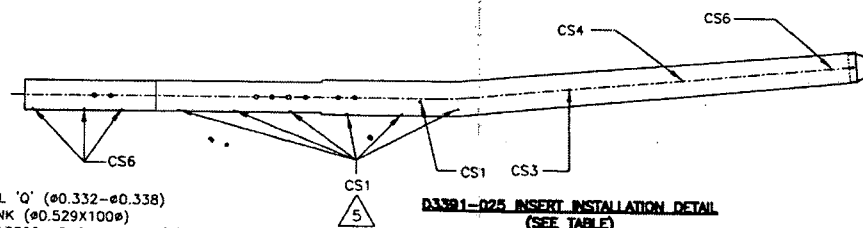
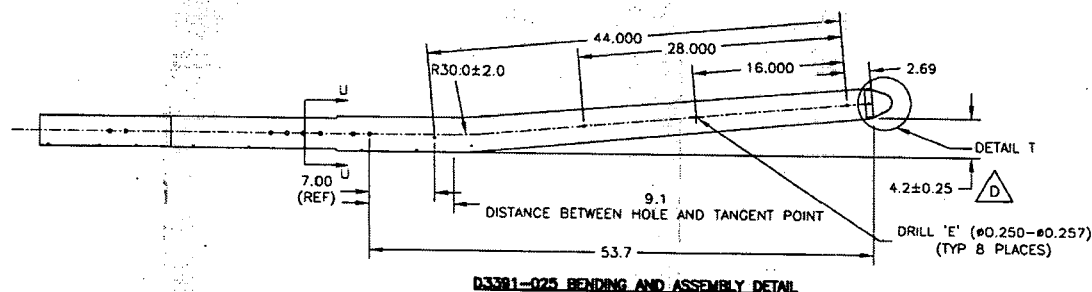


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

#### D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100#)  
NAS1330C4KB151 INSERT (1)  
(4 PLACES)

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CHECKED	APPROVED	DRAWING NO. D3391		REV. D	SHEET 5 OF 5
DATE 06.01.23	TITLE 412 FLOAT SKIDTUBE		SCALE 1:12		

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## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <u>BC</u>	Audited by: <u>S. G.</u>	Prototype Approval: <u>N/A</u>
Date: <u>06.04.05</u>	Date: <u>06/04/08</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



## FIRST ARTICLE INSPECTION CHECKLIST



## First Article



## Prototype

[illegible]

Measured by:	BG
Date:	06-04-05

Audited by:	J. G.
Date:	06/04/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

## Peter Hum

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Friday, April 07, 2006 12:56 PM  
**To:** Peter Hum  
**Subject:** Re: D3391-3 AFT TUBE BORE

Now that I understand that it is just the fwd 14" of the tube where we have bored it out to save weight, I believe that this is an acceptable deviation. There is 0.110" of material left, which I believe will be sufficient.

David

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>  
To: "'David Shepherd'" <davids@dartaero.com>  
Sent: Friday, April 07, 2006 9:21 AM  
Subject: RE: D3391-3 AFT TUBE BORE

> David,  
>  
> To clarify my request and to answer your questions (i've attached another  
> sketch)  
>  
> 1) Its 3.53 constant for 14 inches, the remaining sections are okay  
> 2) This section was not checked in the stress report because we verified  
> the  
> design through testing  
> 3) The purpose of this section was to bore it out to save weight and to  
> move  
> the failure location of the mid tube further forward to allow for higher  
> aft  
> loads  
>  
> Peter  
>  
>

> -----Original Message-----

> From: David Shepherd [mailto:davids@dartaero.com]  
> Sent: Thursday, April 06, 2006 9:39 PM  
> To: Peter Hum  
> Subject: Re: D3391-3 AFT TUBE BORE  
>  
>

> Is it 3.53 all the way? Have you run this dimension through your stress  
> report? How thin does it get at the front end?  
>  
> David  
>  
>

> ----- Original Message -----

> From: "Peter Hum" <phum@dartaero.com>  
> To: "David Shepherd (E-mail)" <davids@dartaero.com>  
> Sent: Monday, April 03, 2006 1:33 PM  
> Subject: D3391-3 AFT TUBE BORE  
>  
>

> > Hi David,

> >  
> > The D3391-3 aft tube bore was drilled out to 3.530 ID the nominal  
> dimension  
> > is 3.500. I've attached a sketch to illustrate it

